



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

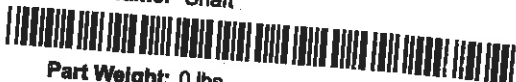
RB6795969-1
Job Sheet 196723



Part No: RB6795969-1

Part Name: Shaft

Job Qty: 4 pcs



Part Weight: 0 lbs

Job Created: 6/20/19

Due Date: 8/2/19

Type: SOLD

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG RB6795969 Rev B IPP Rev. A 19.06.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	4 pcs		8/2/19	1.00	0.80	SL-154 - 1		M.P. 14/07/22
110	QC 2	4 pcs		8/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		M.P. 14/07/22
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S199685

Part: RB6795969 - 1

Job No: 196723

Serial No/Batch: S199685

Revision: 8

Inspector:

Exp Date:

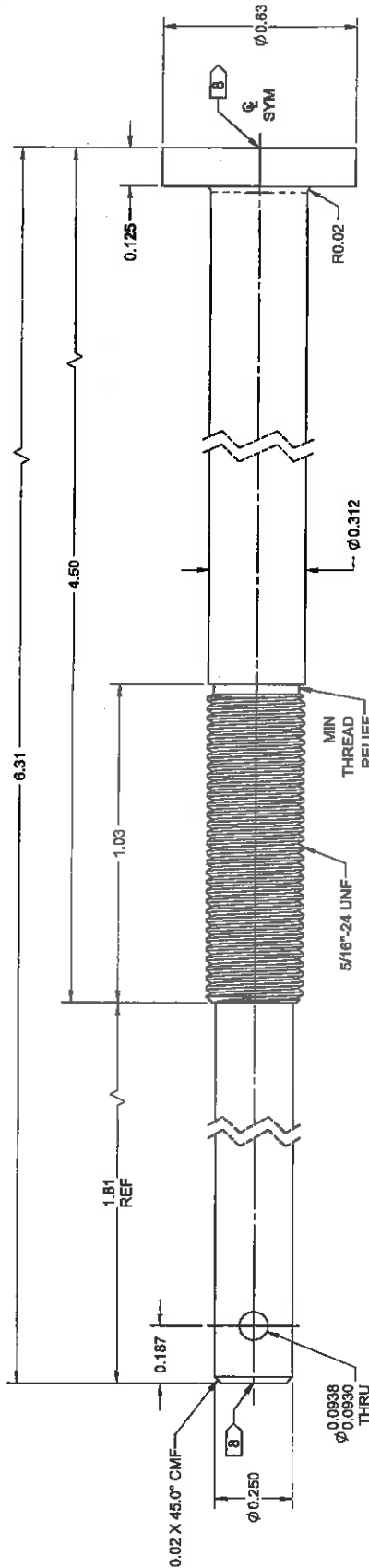
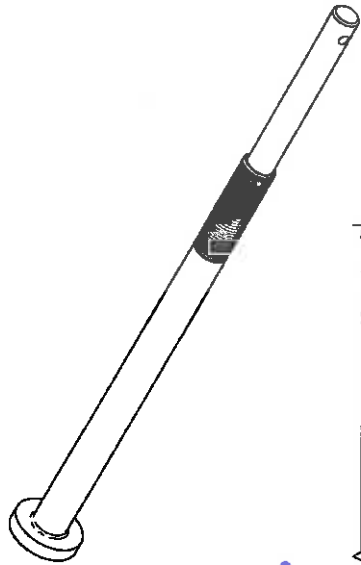
120 QC 8	4 pcs	8/2/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	DA 19-07-23
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Outsource - 12 - Black Oxide	4 pcs	8/2/19		GRO002-VC	DA 2019-07-24
140 Packaging 2-1 - Recelve - B4B	4 pcs	8/2/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP JUL 30 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
Packaging 2 - 26 - B4B					
150 QC 6	4 pcs	8/2/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	81
					JUL 30 2019

Plex 6/20/19 10:15 AM Dart.lajeunesse.marie

				QC 6 - 40	
160	Packaging 3-1 - Stock - B4B	4 pcs	8/2/19	0.00	0.00
	Packaging 3 - 1 - B4B				
	Packaging 3 - 2 - B4B				
	Packaging 3 - 3 - B4B				
	Packaging 3 - 4 - B4B				
	Packaging 3 - 5 - B4B				
	Packaging 3 - 6 - B4B				DAS
	Packaging 3 - 7 - B4B				28
	Packaging 3 - 8 - B4B				9-89
	Packaging 3 - 9 - B4B				
	Packaging 3 - 10 - B4B				
	Packaging 3 - 11 - B4B				
	Packaging 3 - 12 - B4B				
	Packaging 3 - 13 - B4B				
	Packaging 3 - 14 - B4B				
	Packaging 3 - 15 - B4B				
	Packaging 3 - 16 - B4B				
	Packaging 3 - 17 - B4B				
	Packaging 3 - 18 - B4B				
	Packaging 3 - 19 - B4B				
	Packaging 3 - 20 - B4B				
	Packaging 3 - 21 - B4B				
	Packaging 3 - 22 - B4B				
	Packaging 3 - 23 - B4B				
	Packaging 3 - 24 - B4B				
	Packaging 3 - 25 - B4B				
	Packaging 3 - 26 - B4B				
170	QC 21 - SA	4 pcs	8/2/19	0.00	0.00
	QC 21 - SA - 21				
	QC 21 - SA - 70				DAS
	QC 21 - SA - 53				21
Part Op 100 - 1-Machine as per folio FC <u>851</u> FOLIO REV: <u>AA</u> DWG REV: <u>B</u> 2-Debur Descriptions: 130 - -Issue P/O; <u>44113</u> -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required 140 - Certificate of Conformity is required					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-4140QT-R0.625	AISI 4140 Quenched & Tempered Steel Round Bar 0.625" Dia.	2.1600 ft (.54 ea)	100-SL-154 - 1	5124404 (3) 15500	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-SL-154 - 1	MT-4140QT-R0.625	2	97	0	
Part Specifications					
Specifications could not be found.					

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196725 M.C.S
(900-20)



RB6795969-1 SHAFT

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13824 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81308 TYPE III
 - 4) TOLERANCES: X.X = ± 0.1 / ± 0.1
X.XX = ± 0.01 / ± 0.01
X.XXX = ± 0.005 / ± 0.005
X.XXXX = ± 0.0005 / ± 0.0005
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
REMOVE ALL SHARP EDGES AND BURRS
IDENTIFICATION: N/A
CENTER DRILL IS ACCEPTABLE

DESIGN	VM	VM	REV. B
DRAWN	VM	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED			SCALE
INFO. APPR.			SHEET 2 OF 5
APPROVED			NTS
DATE	2019-06-12		
DART AEROSPACE LTD			
HAWKESBURY, ONTARIO, CANADA			
TOOL PART #			
RB6795969			
TITLE			
HOLDER TORQUEMETER SHAFT SUPPORT			

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS																																																																	
Date : _____		Sequence #: _____		QTY Affected : _____																																																																	
Description Work Order Deviation		Disposition		MRB (QS1042)																																																																	
Root Cause <table border="1"><tr><td>Operator</td><td>☐</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY																																																			
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		Completed By																																																																			
		Lead hand / Supervisor																																																																			
		QC / QA Coordinator																																																																			

INSPECTION SHEET

MAJOR O.D
M.O.W

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044113



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044113

PO Date: 7/24/19

Due Date: 8/1/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196531	RB T103388- 101-103	Alignment Tail Rotor Driveshaft Bolt -Issue P/O; -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL- PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/1/19	24 pcs	0 pcs	24 pcs	\$3.7357/pcs	\$89.66
2	194687-A	RBA8100- 80902-201	Wrench -Issue P/O; -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL- PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/1/19	4 pcs	0 pcs	4 pcs	\$4.9357/pcs	\$19.74



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB044113



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	197521	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		8/1/19	20 pcs	0 pcs	20 pcs	\$3.2857/pcs	\$65.71
				X20				JUL 30 2019		DP	
4	194332	RBT18666-5	Slotted Plate -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		8/1/19	8 pcs	0 pcs	8 pcs	\$21.25/pcs	\$170.00
				X8				JUL 30 2019		DP	
5	196723	RB6795969-1	Shaft -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		8/1/19	4 pcs	0 pcs	4 pcs	\$6.2857/pcs	\$25.14
				X4				JUL 30 2019		DP	
6	197519	RBE350A94-2708-01-15	Rod Assembly -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		8/1/19	4 pcs	0 pcs	4 pcs	\$6.6357/pcs	\$26.54
				X4				JUL 30 2019		DP	
Grand Total:										\$396.80	



Dart Aerospace Ltd.
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K6A 1K7
Canada

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PURCHASE ORDER POHB044113



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/30/19 8:11 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021040-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021040 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
30-Jul-2019		Jigar Patel			POHB044113			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ HC Qty	Qté Scrap/	À venir/ Back Order
1	RBT103388-101-103 Rev.	RBT103388-101-103 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	24	24	0	0	0
2	RBA8100-80902-201 Rev.	RBA8100-80902-201 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
3	RBE350A94-2706-00-03 Rev.	RBE350A94-2706-00-03 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	20	20	0	0	0
4	RBT18666-5 Rev.	RBT18666-5 ANO-BLACK [ANODIZE BLACK] AS PER IAW MIL-A-8625F TYPE 2, CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	0
5	RB6795969-1 Rev.	RB6795969-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
6	RBE350A94-2708-01-15 Rev.	RBE350A94-2708-01-15 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0

RECEIVED
JUL 30 2019
CART AEROSPACE LTD.

RECEIVED

JUL 30 2019

DART AEROSPACE LTD.



Certificat de Conformité / Certificate of Compliance

(021040-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021040 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
30-Jul-2019		Jigar Patel			POHB044113			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J. JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.